

Date: Thursday, 11/9/2006 4:37:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, RH, 206
Job Number	: 29389		
Estimate Number	: 10523		
P.O. Number	: <i>N/A</i>	Part Number	: D26652
This Issue	: 11/9/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2665 REV. C
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 28602	Drawing Revision	: <i>C</i>
	Type : MACHINED PARTS	Material	: <i>S/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/28/2006
Checked & Approved By	: <i>[Signature]</i> 06 11 10	Qty:	12 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

B 25346 ml 06/11/22

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

SD/ml 06/11/22

PTG

12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

ml 06/11/22

12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/ml 06/11/22

12

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Er 06/11/23 + 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 1265-2 PAR #: N/A Fault Category: Prod / Machine ^{fix} NCR: Yes No DQA: Yes Date: 04/11/28
 QA: N/C Closed: Yes Date: 06.11.28

NCR: <u>29387</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.11.10	2	Dwg does not match tooling / program	<u>UP</u> 06.11.10 per QSI 642	CROSSHOLE-TO-SADDLE HOLES SHOULD BE DRILLED Ø0.316- TOLL RAD IN POLKETING OF FLANGE SHOULD BE R0.188. SEE MARKED UP DWG, SEE DS EMAIL	<u>gml</u> 06/11/22	<u>UP</u> 06.11.10 per QSI 642	<u>UP</u> 06.11.10 per QSI 642	<u>UP</u> 06.11.10 per QSI 642
06/11/21	2	the shid bolt face are too thin of .030"	<u>UP</u> 06/11/22	desire and replace give to org	<u>gml</u> 06/11/22	<u>UP</u> 06/11/22	<u>UP</u> 06/11/22	<u>UP</u> 06/11/22

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 29389

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YLC 06/11/24 X 12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YLC 06/11/27 X 12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

106/10/28 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 482 *AL 4/11/28 (12)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)
SP 06/11/28

Job Completion



C Log 06/11/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29389
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.121	0.121	0.118	0.121		
B	0.100	0.140		0.128	0.125	0.128	0.125		
C	1.125	1.145		1.135	1.135	1.134	1.134		
D	0.615	0.685		0.685	0.680	0.680	0.680		
E	0.240	0.260		0.253	0.254	0.253	0.253		
F	1.313	1.343		1.325	1.328	1.326	1.336		
G	0.210	0.230		0.229	0.223	0.222	0.222		
H	0.100	0.180		0.130	0.140	0.140	0.140		
I	2.470	2.510		2.493	2.495	2.493	2.493		
J	1.565	1.585		1.574	1.573	1.572	1.572		
K	0.235	0.240		0.237	0.239	0.237	0.237		
L	0.100	0.120		0.115	0.115	0.113	0.114		
M	0.990	1.010		1.000	1.002	1.003	1.001		
N	0.510	0.515		0.500	0.512	0.512	0.512		
O	5.990	6.010		6.000	5.999	6.000	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.313	0.318		0.320	0.320	0.320	0.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.362	1.361	1.361		
V	0.787	0.807		0.796	0.800	0.799	0.797		
W	0.540	0.560		0.548	0.550	0.550	0.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.918	0.917	0.921	0.921		
AA	0.490	0.510		0.500	0.502	0.501	0.501		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>cm</i>
Date:	06/11/22

Audited by:	<i>SC</i>
Date:	06/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	29389
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. C		Page 1 of 1

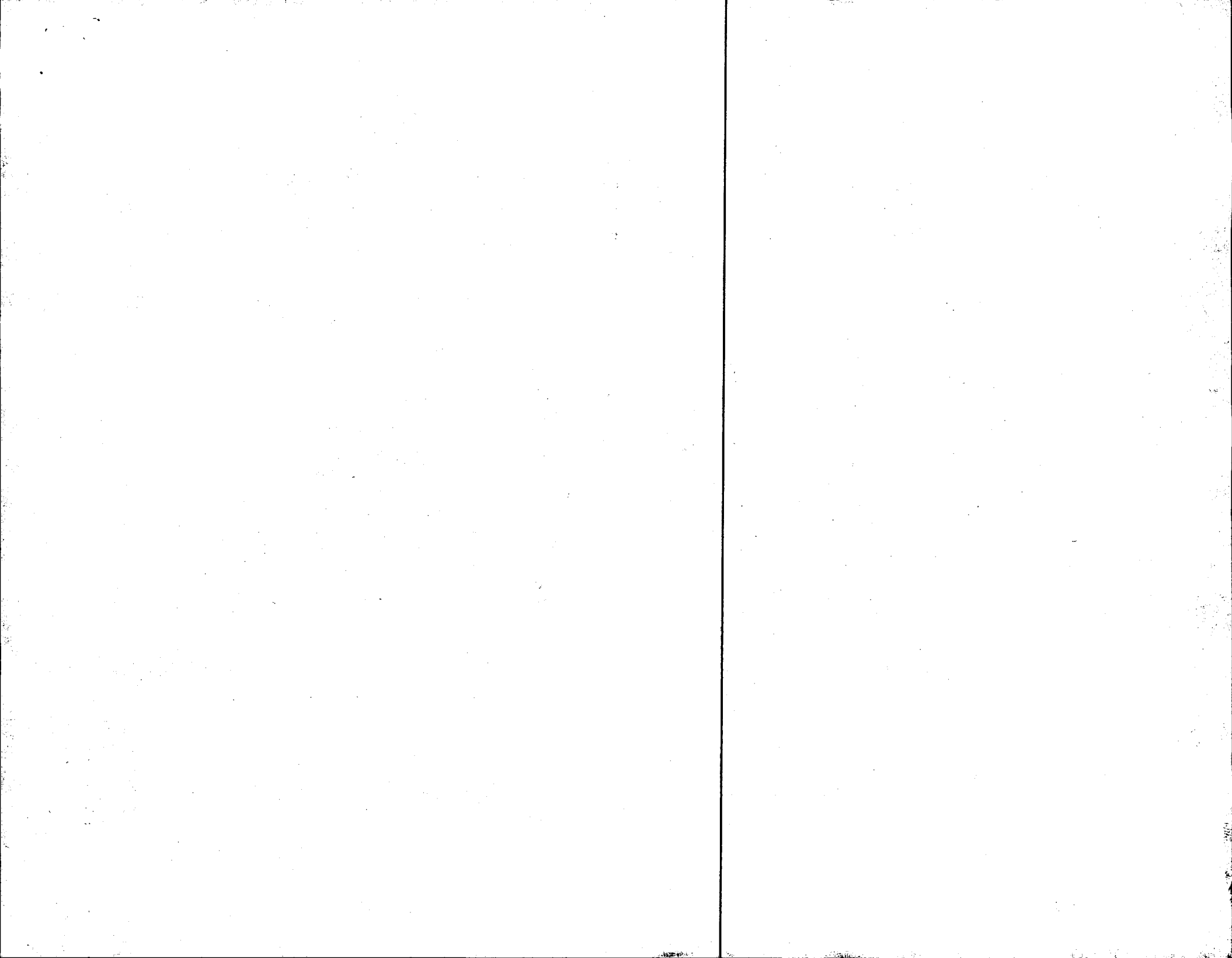
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.119	0.122	0.119	0.119		
B	0.100	0.140		0.128	0.122	0.128	0.127		
C	1.125	1.145		1.134	1.135	1.135	1.133		
D	0.615	0.685		0.682	0.682	0.680	0.680		
E	0.240	0.260		0.254	0.253	0.254	0.253		
F	1.313	1.343		1.328	1.331	1.329	1.328		
G	0.210	0.230		0.223	0.223	0.222	0.223		
H	0.100	0.180		0.140	0.138	0.137	0.140		
I	2.470	2.510		2.493	2.493	2.493	2.493		
J	1.565	1.585		1.572	1.572	1.572	1.571		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.113	0.112	0.114	0.115		
M	0.990	1.010		1.002	1.004	1.003	1.003		
N	0.510	0.515		0.511	0.511	0.512	0.512		
O	5.990	6.010		6.000	6.000	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.506	2.500	2.500		
R	0.313	0.348		0.324	0.314	0.314	0.314		
S	0.313	0.348		0.320	0.320	0.320	0.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.796	0.796	0.797		
W	0.540	0.560		0.550	0.550	0.550	0.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.921	0.921	0.922	0.923		
AA	0.490	0.510		0.503	0.501	0.501	0.500		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	gml
Date:	06/11/22

Audited by:	En
Date:	06/11/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	



DART AEROSPACE LTD	Work Order:	29389
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

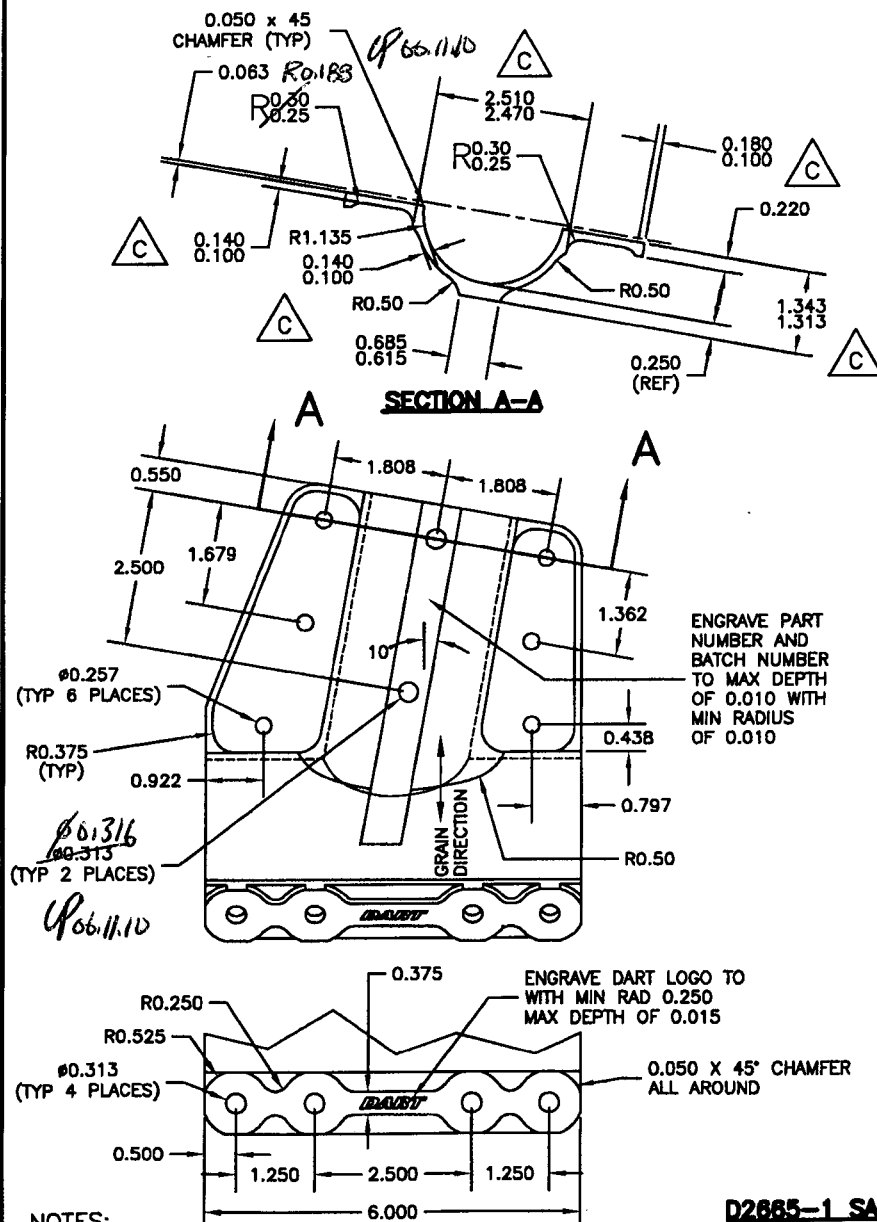
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.119	0.119	0.121	0.121		
B	0.100	0.140		0.128	0.129	0.128	0.128		
C	1.125	1.145		1.134	1.134	1.135	1.135		
D	0.615	0.685		0.682	0.680	0.680	0.680		
E	0.240	0.260		0.253	0.253	0.253	0.253		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.210	0.230		0.222	0.222	0.222	0.222		
H	0.100	0.180		0.140	0.140	0.140	0.140		
I	2.470	2.510		2.493	2.493	2.493	2.493		
J	1.565	1.585		1.572	1.573	1.572	1.573		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.115	0.114	0.114	0.114		
M	0.990	1.010		1.003	1.003	1.003	1.003		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.001	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.343	0.348		0.320	0.320	0.320	0.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.795	0.796	0.797		
W	0.540	0.560		0.550	0.549	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.921	0.921	0.921	0.921		
AA	0.490	0.510		0.501	0.501	0.501	0.500		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	amf	Audited by:	En
Date:	06/11/22	Date:	06/11/23

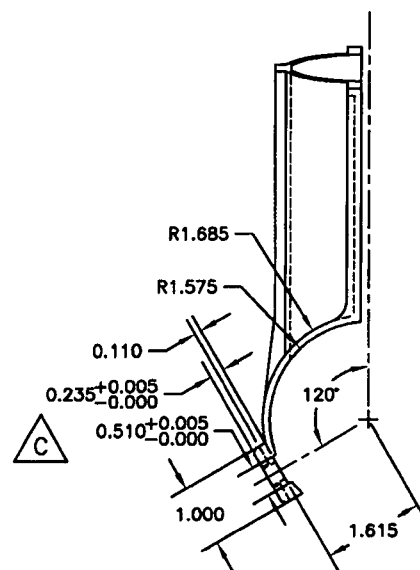
Rev	Date	Change	Revised by	Approved
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C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
	C.B.	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2665	SHEET 1 OF 1
DATE		TITLE	SCALE
06.05.29		SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	



RELEASED
06.06.28
UNDER REVIEW
06.05.26
0.3.3 OK 06.11.10

**NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

D2665-1 SADDLE FWD OUTSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29389

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

10/11/2006

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: September 21, 2006 2:58 PM
To: 'Chris Provencal'
Cc: 'C Bell'; 'S Shahbazian'
Subject: RE: D2665 Saddle

This is acceptable.

For some reason, I thought someone was in the process of fixing these drawings (Chris Bell?)

In fact, I may have already signed them.

Please look into it.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, September 21, 2006 7:26 AM
To: David Shepherd (David Shepherd)
Subject: D2665 Saddle

David,

The two 0.313 OD saddle-to-crosstube holes, the dwg says 0.313, the folio is evidently calling for a 0.316 drill. The 0.316 is required to fit the part on the tooling, they must have been using 0.316 for some time. Anyhow, they want the drawing changed to 0.316 (I don't see a big problem with that), but for now they need an email to sign of this latest batch as a deviation on the work order. Ultimately this would affect all the 206 saddles. Is 0.316 OD acceptable for the saddle-to-crosstube holes on the D2665 saddles?

Chris

--
No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.1.405 / Virus Database: 268.12.5/451 - Release Date: 9/19/2006

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No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

10/11/2006